



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2580-1
Job Sheet 176917



Part No: D2580-1

Job Qty: 8 ea

Part Name: 205 Bent Tube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/3/18

Job Tracking No:

Due Date: 5/11/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG D2580 REV h SHEETS 1,2,3,8 IPP B 01.11.08 Revised Step 9, 10, 12, and 13 SM IPP Rev:C 10.12.01 as per DEO D1 DD ver:ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	5/11/18	5/11/18	0.00	0.00	Start Up Skidtubes		J.Y.
100	Skidtubes	8 pcs	5/11/18	5/11/18	0.00	7.41	Skidtubes		J.Y.
101	QC	8 pcs	5/11/18	5/11/18	0.00	0.00	QC5		J.Y.
110	HandFinish	8 pcs	5/11/18	5/11/18	0.00	3.33	HandFinish1		J.Y.
120	QC	8 pcs	5/11/18	5/11/18	0.00	0.00	QC7		J.Y.
125	Skidtubes	8 pcs	5/11/18	5/11/18	0.00	7.41	Skidtubes		J.Y.
130	QC	8 pcs	5/11/18	5/11/18	0.00	0.00	QC5		J.Y.
140	Packaging	8 pcs	5/11/18	5/11/18	0.00	0.00	Packaging3		J.Y.
150	QC21-SA	8 Ea	5/11/18	5/11/18	0.00	0.00	QC21		J.Y.

Part Op 100 - 1- Inspect mat'l D2500-1-190 for damage. 2-Drill pilot holes using drill jig DT 8149 A-BC-D 3-Open holes to 0.508" Descriptions: as per Dwg D2580 4-Deburr holes per QSI002 section 4.2.3 and blow out all chips from inside of tube 5- Test fit inspection saddles on FWD & AFT saddle holes using DT9916.
125 - 1- Bond web in place per QSI 015. A/R Sikaflex-291 batch: M198707 Sikaflex expire date: Dec 2018 Start time and date: _____ bond for 12hrs
140 - LOCATION : LG002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-1-190	Ext'n -I' Beam Tube 4"	4 Ea (1 ea)	90-Start up Operation	50 J7163
D2596	Web, 205 Skidtube	4 Ea (1 ea)	125-Skidtubes	JX5050141

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2500-1-190	4	58	0
125-Skidtubes	D2596	4	2	0

Part Specifications

Specifications could not be found.



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Container No: S068577



Part: D2580-1
Job No: 176917
Serial No/Batch: S068577
Revision: H
Inspector:

Date: 05/04/18

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1/1/52